



**DESCRIPTION**

- a surface tolerant two component direct to metal high build epoxy mastic coating
- approved to APAS-2977
- conforms to AS/NZS 3750.1 and AS/NZS 3750.14

**PRINCIPAL CHARACTERISTICS**

- excellent wetting properties and corrosion resistance
- self priming coating tolerant to lower grades of steel preparation where blast cleaning may not be possible
- suitable for immersion in fresh and salt water when applied over suitably prepared surfaces
- compatible with various aged coatings
- excellent flexibility
- excellent abrasion resistance
- very low water permeability
- for recoating with highly durable topcoats such as polyurethanes and catalysed acrylics, an intermediate coat such as Epinamel PR250 or Epinamel PR300ZP is required

**COLOURS AND GLOSS**

- Aluminium, White, Black, Grey - semi-gloss

**BASIC DATA AT 25 °C**

- solids content..... approx. 82% by volume
- mix ratio ..... 5A:1B by volume
- typical film thickness (per coat) ..... 150 - 400 microns(dry), 180 - 480 microns(wet)
- theoretical spreading rate ..... 5.5 m<sup>2</sup>/l for 150 microns(dry)  
2.1 m<sup>2</sup>/l for 400 microns(dry)
- touch dry after ..... 6 hours
- overcoating interval..... refer to overcoating table for details
- full cure after ..... 7 days
- shelf life (cool and dry place) ..... at least 12 months

**RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE**

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- mild steel; power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9), (atmospheric exposure only)
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be at least 5 °C during surface preparation, application and curing and at least 3 °C above dew point
- relative humidity should not exceed 85%

**INSTRUCTIONS FOR USE**

- mixing ratio by volume 5A:1B
- mix with EpinameL DTM900 Part B only
- induction time - none
- pot life at 25°C 1 hour. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- for application over heavily rusted and pitted substrates, thin up to 35% with L760 thinner to avoid bubbling from air entrapment
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to WattyL

**APPLICATION**

- **AIRLESS SPRAY**
  - recommended thinner .....L760
  - volume of thinner .....not normally required, may be thinned up to 5% for low film build range
  - nozzle orifice .....approx. 0.48 - 0.53mm (0.019 - 0.021 inch)
  - nozzle pressure.....15 MPa (2100 psi)
- **AIR SPRAY**
  - recommended thinner .....L760
  - volume of thinner .....up to 15%
  - nozzle orifice .....1.8 - 2.0 mm
  - nozzle pressure.....0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**
  - recommended thinner .....L760
  - volume of thinner .....up to 10%

The maximum dry film thickness that can be achieved when brushing/rolling is 100 microns  
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** .....L760

**SAFETY PRECAUTIONS**

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA****Overcoating table - with Epiname DTM900 or epoxy coatings**

Substrate temperature	10°C	15°C	25°C	35°C
Minimum interval	36 hrs	24 hrs	16 hrs	8 hrs
Maximum interval	3 months	3 months	3 months	3 months

**Overcoating table - with SeaPro TC90 or chlorinated rubber coatings**

Substrate temperature	10°C	15°C	25°C	35°C
Minimum interval	36 hrs	24 hrs	16 hrs	8 hrs
Maximum interval	14 days	14 days	14 days	14 days

- surface must be dry and free from any chalking or contamination prior to application

**Curing table**

Substrate temperature	Touch dry	Dry to handle	Full cure
10°C	24 hrs	48 hrs	20 days
15°C	12 hrs	24 hrs	10 days
25°C	6 hrs	16 hrs	7 days
35°C	4 hrs	8 hrs	4 days

- adequate ventilation must be continuously maintained during application and curing

**Pot life (at application viscosity)**

Paint temperature	Pot life
15°C	2 hrs
25°C	1 hr
35°C	30 mins

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